

**Work Order ID 58077**

April 22, 2010 2:25:08 PM



Page 1

Item ID: D4049-4

Accept



Setup Start



Revision ID:

Item Name: Mounting Plate, RH

Stop



Start Date: 4/22/10 Start Qty: 2.00



Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *PL*Date: *10-11-22* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description
--------------------------------	--------------------------

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D4049	B

100

0.00

*A10.04.27*  
 Memo *as pending*  
 1-Cut sheet at 6.00" X 5.00"  
 Dwg Rev: *B*  
 Prog Rev: *B*
*B 10-4-26*
*(2)*

110

0.00

 Memo  
 Form as per dwg D4049

*RE-10-4-26*
*A 10.04.27 (2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC5- Inspect part completeness to step on W/O

0.00

S. 4/4/07

X2

QC

Quality Control

130



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per dwg D4049

Dwg Rev:

Prog Rev:

2-Debuff

0.00

HB 10-4-26



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

S. 4/4/07

X2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**Work Order ID 58077**

April 22, 2010 2:25:09 PM

Page 3

Item ID: D4049-4

Accept



Setup Start



Revision ID:

Item Name: Mounting Plate, RH

Stop



Start Date: 4/22/10 Start Qty: 2.00



Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

150 100.2



QC

Quality Control

Operation  
Description

QC8- Inspect parts - second check

Set Up/  
Run Hours

0.00

Draw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

S10462

XZ

160



Packaging

Packaging

Identify as per dwg & Stock Location: W/O

0.00

Memo

58073

0.00

EL 10-5-3

170



Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/05 AF

MF  
10-5-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

April 22, 2010 2:25:08 PM

Page 1

Work Order ID: 58077



Parent Item: D4049-4



Parent Item Name: Mounting Plate, RH

Start Date: 4/22/10

Required Date: 4/30/10

Comments: IPP RevA: new issue DD 10.01.12 verified by:EC IPP Rev:B as per dwg  
revA DD 10.02.18 verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	14.2200	0.4208			



304/316 0.125 Sheet

HB 10-4-26

## Warehouse

### Location

Main Warehouse

MAT19 14.22

112663 14.22

114488

## Loc Qty

## Loc Code

114488

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	S8077
Description: MANTING PLATE RTT	Part Number:	D4049-4
Inspection Dwg:D4049-4 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X

## **First Article**

X

## Prototype

Measured by:	FB
Date:	10-4-20

Audited by:	S
Date:	10/06/22

<b>Prototype Approval:</b>	
<b>Date:</b>	

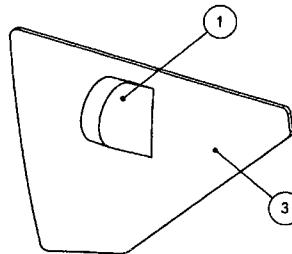
<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1

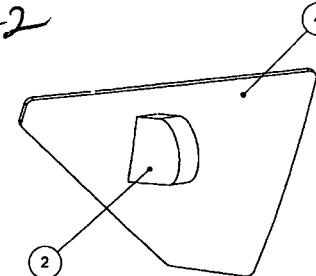
ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D4049-041	MOUNTING LUG ASSY, LH
		X	D4049-042	MOUNTING LUG ASSY, RH
1	1		D4049-1	LUG
2		1	D4049-2	LUG
3	1		D4049-3	MOUNTING PLATE, LH
4		1	D4049-4	MOUNTING PLATE, RH

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 58077

BY 10-4-22



D4049-041 MOUNTING LUG ASSY, LH



D4049-042 MOUNTING LUG ASSY, RH

RELEASED  
2010-04-14  
NFO

B	80 * WAS 83 *, 0.33 WAS 0.55 & 2.10 WAS 2.50 (ZN C6-2)	RF	10.03.19
A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	DRAWING NO.	REV. B
MFG. APPR.	#	D4049	SHEET 1 OF 7
APPROVED	#	TITLE	SCALE
DE APPR.	#	MOUNTING LUG ASSY	NTS
DATE	10.03.19	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR SHOWN TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

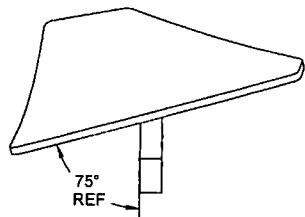
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

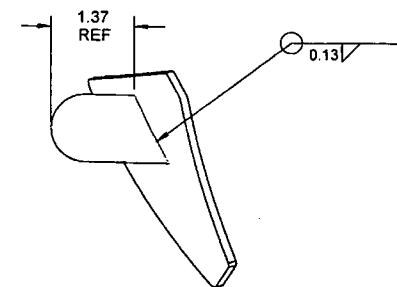
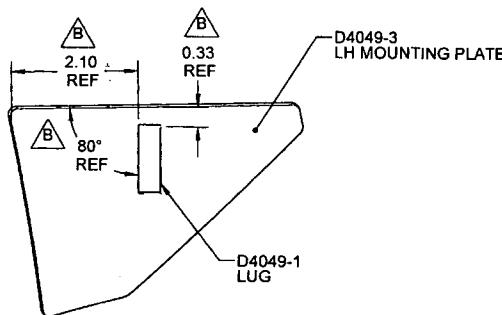
D



WLO 58077

C

C



8 D4049-041 MOUNTING LUG ASSY, LH

RELEASED  
2010-04-14  
JW

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs
- 8) WELD PER DART QSI 004 USING WELDING JIG DT9584

8 7 6 5 4 3 2 1

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	##	DRAWING NO.
MFG. APPR.	##	D4049 REV. B
APPROVED	##	SHEET 2 OF 7
DE APPR.	##	TITLE
DATE	10.03.19	SCALE
		NTS

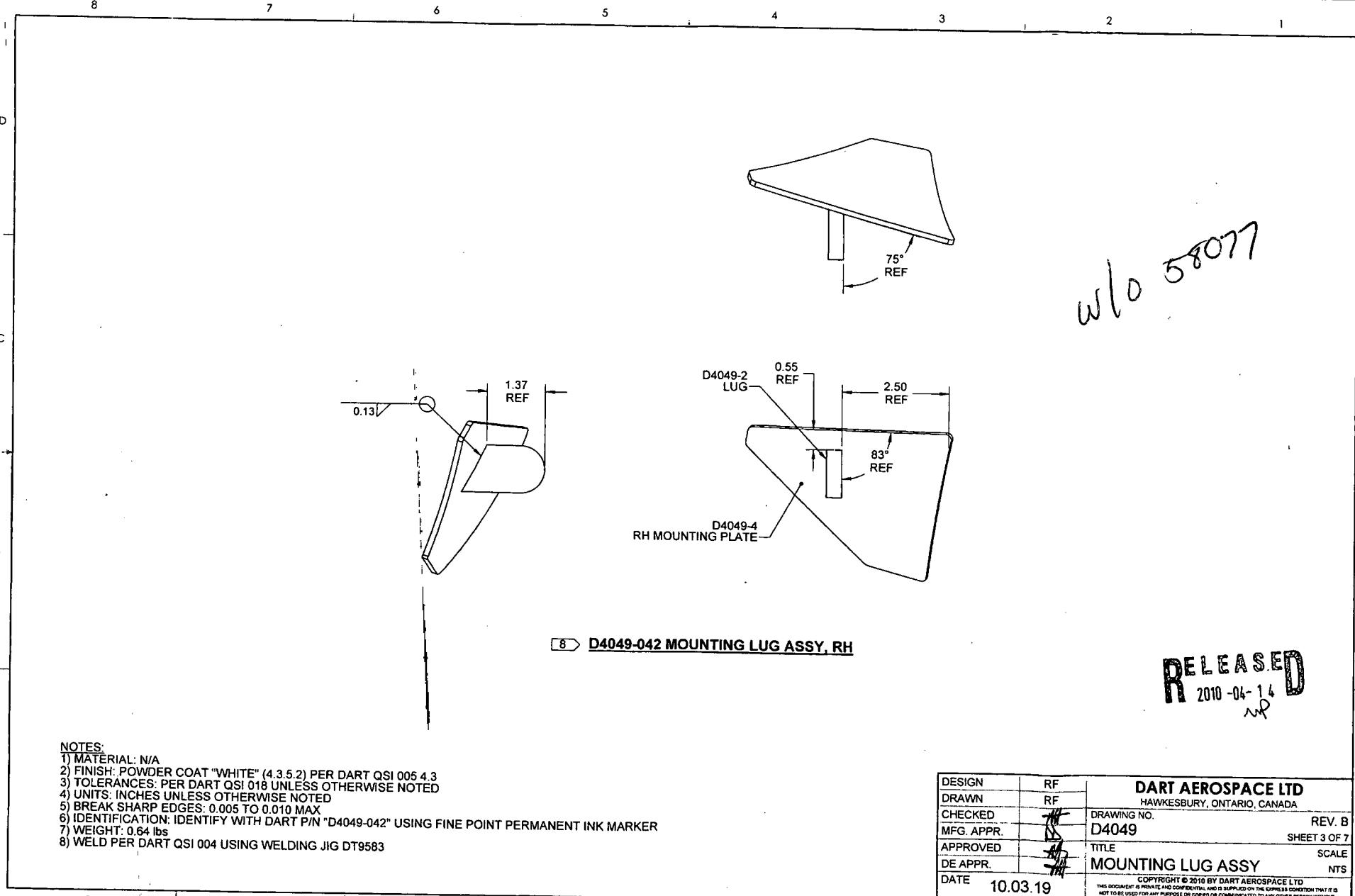
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NOTE: Date & initial all entries



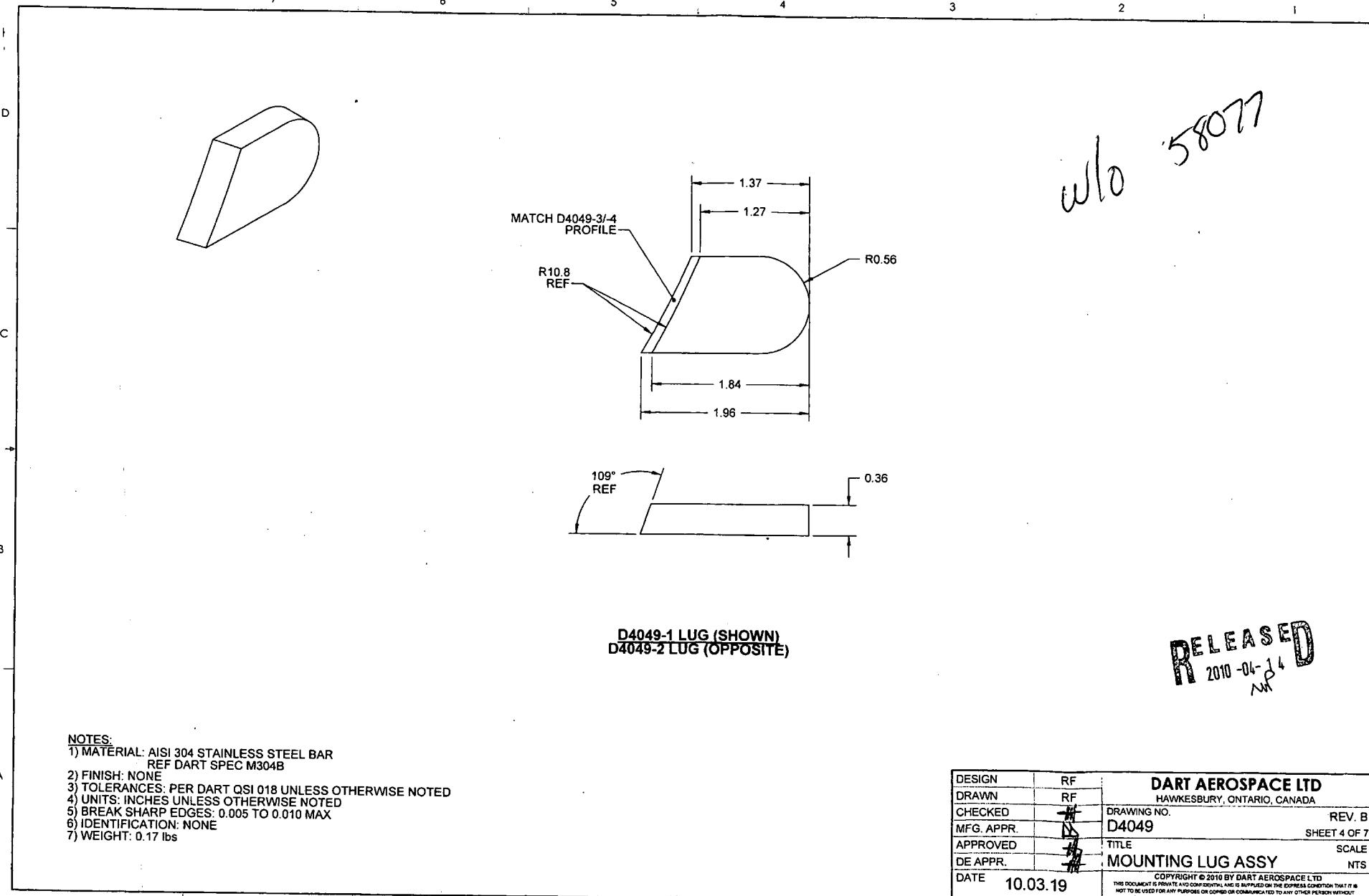
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NOTE: Date & initial all entries



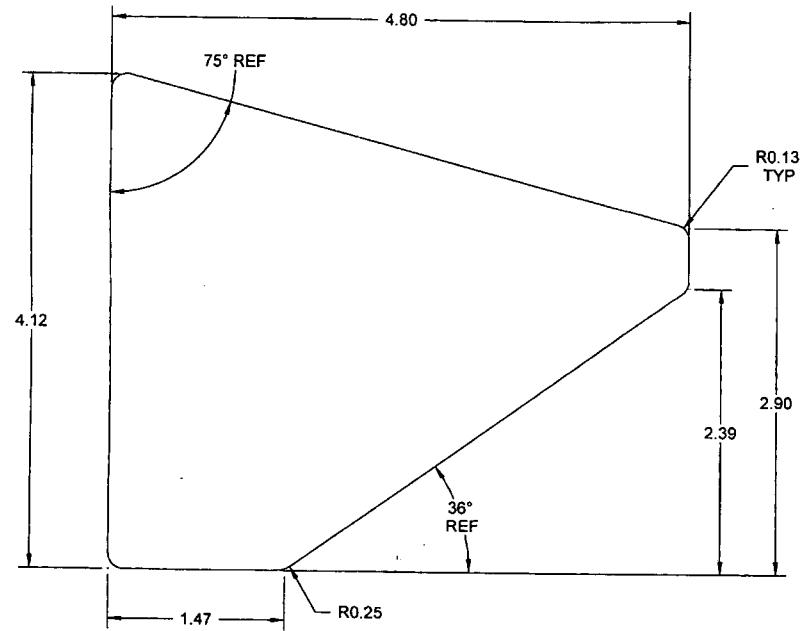
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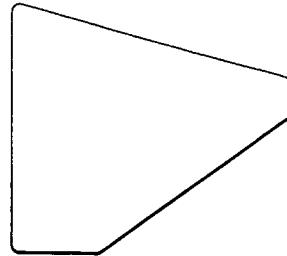


D4049-3F FLAT PATTERN

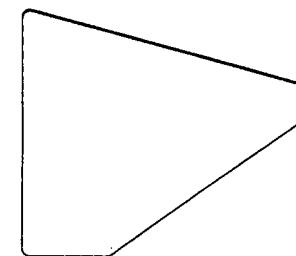
W(0) 58077

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH, 0.125" THICK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.46 lbs



**D4049-3 MOUNTING PLATE, LH**  
(MAKE FROM D4049-3F FLAT PATTERN)



**D4049-4 MOUNTING PLATE, RH**  
(MAKE FROM D4049-3F FLAT PATTERN)

**RELEASED**  
2010-04-14

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		REV. B	
APPROVED		D4049	
DE APPR.		SHEET 5 OF 7	
DATE	10.03.19	TITLE MOUNTING LUG ASSY	
		SCALE NTS	

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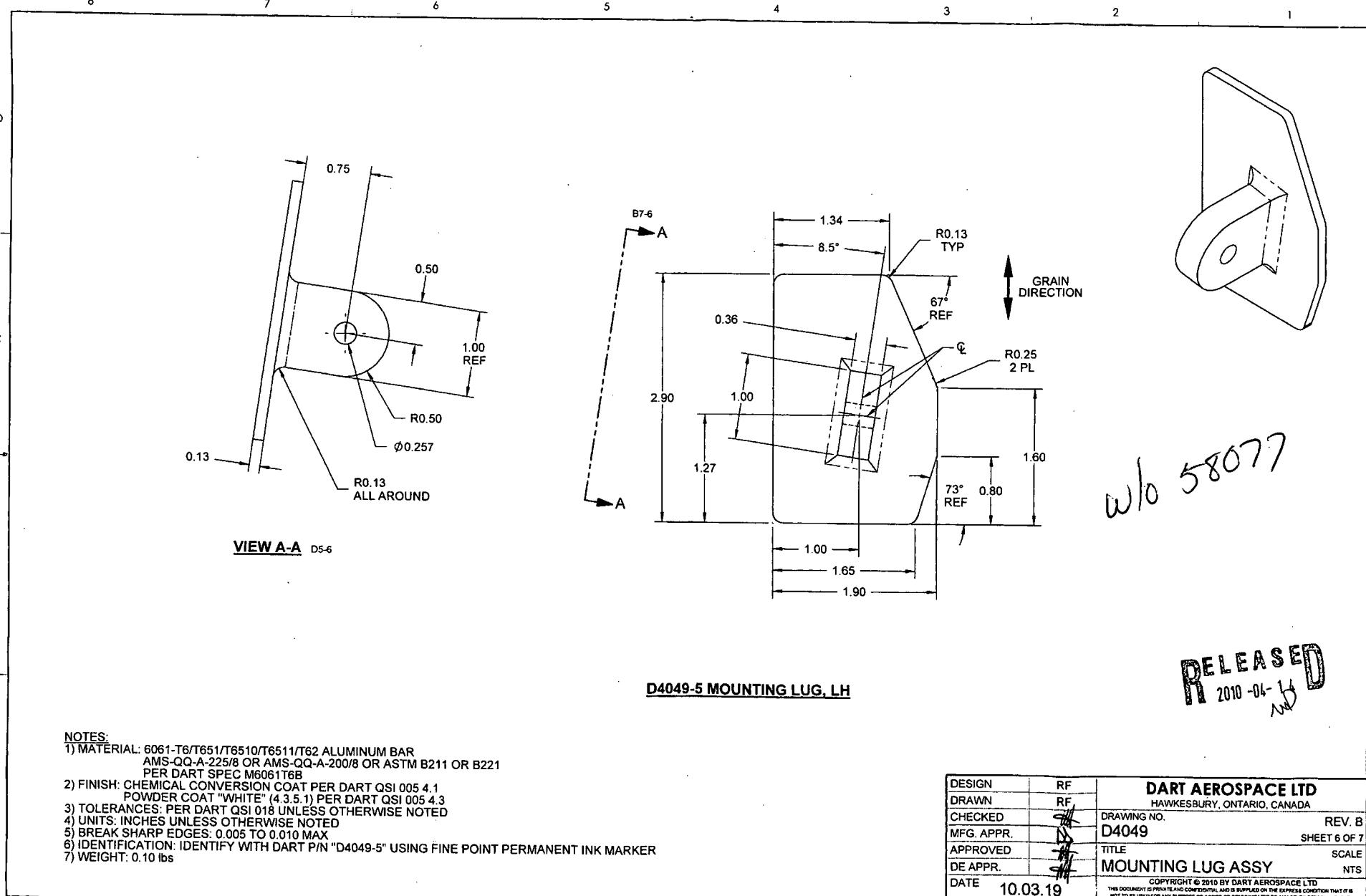
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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MFG. APPR.	<i>[Signature]</i>	REV. B
APPROVED	<i>[Signature]</i>	SHEET 6 OF 7
DE APPR.	<i>[Signature]</i>	TITLE <i>[Signature]</i>
DATE	10.03.19	SCALE NTS

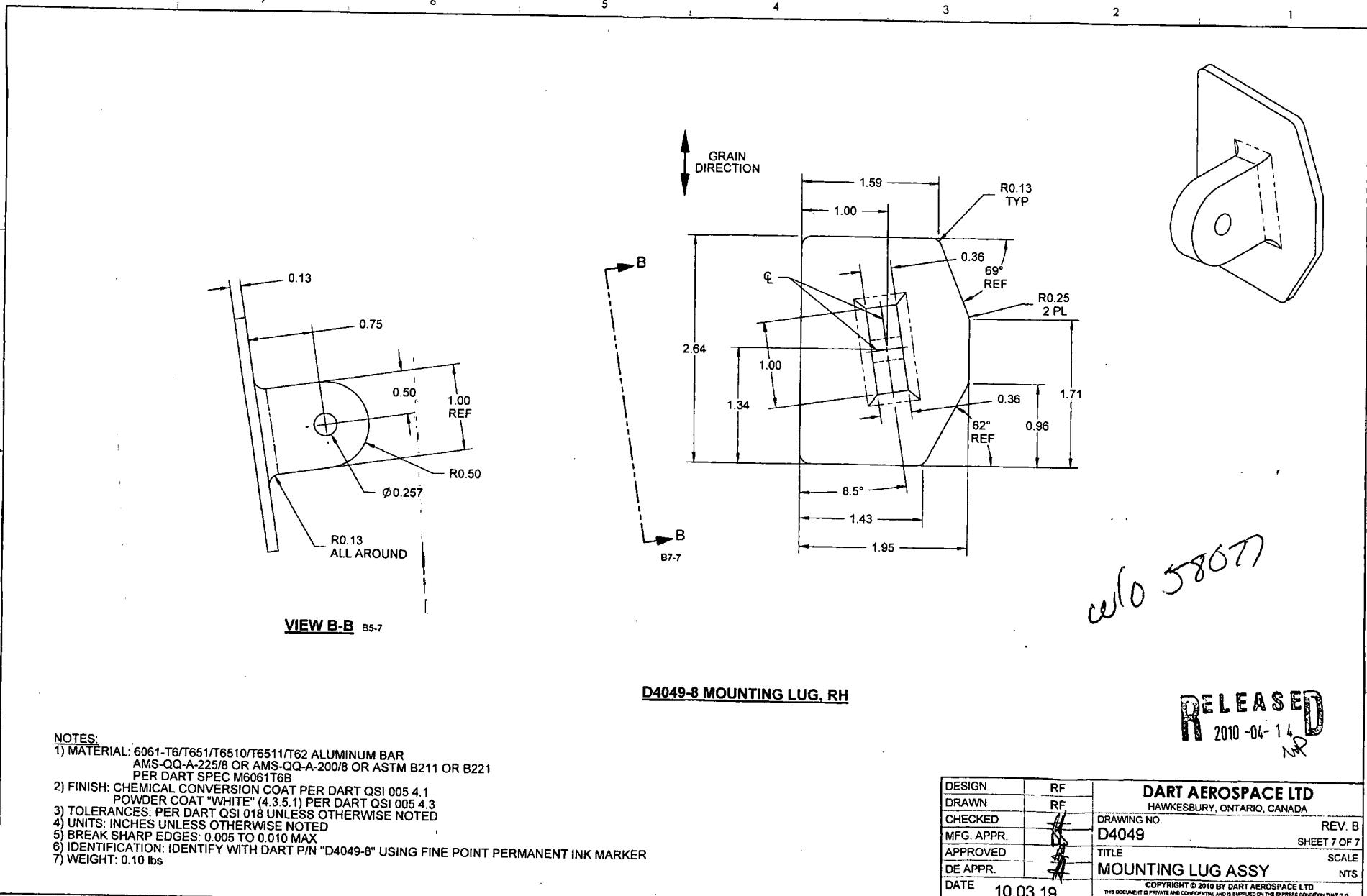
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**NOTES:**

- 1) MATERIAL: 6061-T6/T6510/T6511/T62 ALUMINUM BAR  
AMS-QQ-A-225/8 OR AMS-QQ-A-200/8 OR ASTM B211 OR B221  
PER DART SPEC M6061T62
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-8" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs

W/O:		WORK ORDER CHANGES					
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